

Work Order ID 86884

86884

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July-09-12 9:15:10 AM

Item ID: D2278 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Leg
 Start Date: 7/06/12 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: Date: 12-07-10 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2278	Rev F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2278 Dwg Rev: <u>F</u> Prog Rev: <u>F</u> 2-								
666 : 086	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
15
17/6/12

(+32)

B12-7-19

B12-7-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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July-09-12 9:15:10 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/06/12 **Start Qty:** 30.00 ***30***

Cust Item ID:

Required Date: 7/06/12 **Req'd Qty:** 30.00 ***30***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

130

Memo

0.00

HandFinish

Hand Finishing

0.00

140

Memo

0.00

QC

Quality Control

Identify as per dwg & Stock Location: C-A

0.00

150

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
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Work Order ID 86884

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July-09-12 9:15:10 AM

Item ID: D2278

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Leg

Start Date: 7/06/12

Start Qty: 30.00

30

Cust Item ID:

Required Date: 7/06/12

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12/07/25

mk 12-07-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 86884

Parent Item: D2278

Parent Item Name: Step Leg

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
 IPP Rev:B Now 6061-T6 06-06-23 JLM
 IPP Rev C New flat pattern 08.01.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	314.8743	0.9815	30.994737		B12-7-19	

Location

Loc Qty

Loc Code

MAT021

314.874316

117285

0.124316

119766

39.6

120096

261.45

121193

13.7

120096

3

W/O:		WORK ORDER CHANGES					
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02

F	CHANGE ØØ.213 HOLES TO ØØ.213 X .750 SLOT CHANGE SOME DIMENSIONS TO XXX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 283	PH	07.12.27
E	ADD 6061-T6 MATERIAL	CB	06.05.29
D	AOD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.08
A	NEW ISSUE	BW	94.10.13
REV.	DESCRIPTION	BY	DATE
	DRAWING NO.		
	D2278		
	TITLE		
	LEG		
DATE	07.12.27		

HAWKESBURY, ONTARIO, CANADA
DART AEROSPACE LTD
 REV. F
 SHEET 1 OF 1
 SCALE
 3.2:1

METHOD OF MANUFACTURE AND CONSTRUCTION SHALL BE AS SHOWN BY THE PARTS SPECIFICATION AND THIS DRAWING.
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RELEASED
JUL 01 10 14

56889
#12-0710

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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